

**Work Order ID 63885**

Thursday, November 18, 2010 9:25:11 AM

Page 1

Item ID: D4274-3  
Revision ID: PRELIM  
Item Name: Plate, Aft Support

Accept

Setup Start

Stop

Start Date: 11/18/2010 Start Qty: 4.00  
Required Date: 11/19/2010 Req'd Qty: 4.00

Cust Item ID:  
Customer:



**PRELIMINARY ISSUE**

Reference:

Approvals: Process Plan: mf Date: 10-11-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY 08/10/11/23</div>							
D4274	PA1								
100		0.00							
 Waterjet	Memo 1-Cut as per Dwg Dwg Rev: <u>PA1</u> Prog Rev: <u>PA1</u> 2-Deburr if necessary	0.00							<u>B10-11-18</u>
FLOW CNC Waterjet <u>304 .128</u>									(4)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
 QC	Memo	0.00							<u>B10-11-18</u>
Quality Control									








# Work Order ID 63885

Thursday, November 18, 2010 9:25:11 AM

Page 2

Item ID:	D4274-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Plate, Aft Support					
Start Date:	11/18/2010	Start Qty: 4.00		Cust Item ID:		
Required Date:	11/19/2010	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 - inspected to PA1 Day only 0.00 Swin118 (48)							
130  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00 0.00							
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

VE RECALL  
 AUTH 10-11-19 (4)  
 RELEASED 10-11-23 DATE 10-11-30

# Picklist Print

Page 1

Thursday, November 18, 2010 9:25:10 AM

Work Order ID: 63885



Parent Item: D4274-3



Parent Item Name: Plate, Aft Support

Start Date: 11/18/2010

Required Date: 11/19/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	39.8523	0.357	1.503158			



304/316 0.125 Sheet



BIO-11-18

Location

Loc Qty

Loc Code

MAT

39.8523

114799

39.8523

114799

④

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 63885
<b>Description:</b> PLATE AFT SUPPORT	<b>Part Number:</b> D4274-3
<b>Inspection Dwg:</b> D4274-3, Rev: PA1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

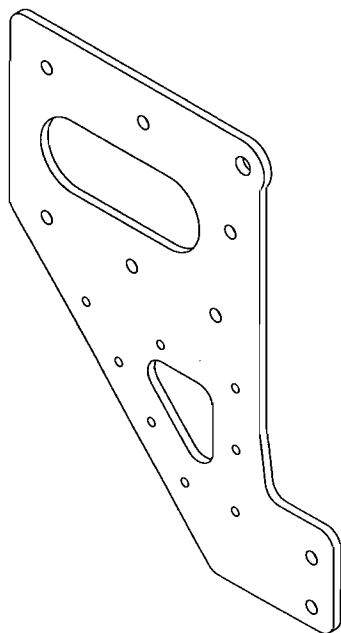
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.132	X		V 1802	
Ø .191	+ .005 - .001	.193	X		V	
Ø .53	+ .012 - .001	.530	X		V	
2.80	± .030	2.801	X		V	
1.05	± .030	1.057	X		V	
.60	± .030	.603	X		V	
1.20	± .030	1.207	X		V	
1.10	± .030	1.091	X		V	
.75	± .030	.750	X		V	
3.000	± .010	2.999	X		V	
1.500	± .010	1.498	X		V	
2.300	± .010	2.293	X		V	
.36	± .030	.361	X		V	
.792	± .010	.792	X		V	
.672	± .010	.662	X		V	
.464	± .010	.457	X		V	
.70	± .030	.697	X		V	
.68	± .030	.681	X		V	
.38	± .030	.379	X		V	
1.123	± .010	1.122	X		V	
1.983	± .010	1.977	X		V	
.991	± .010	.987	X		V	

<b>Measured by:</b> AS	<b>Audited by:</b> S	<b>Prototype Approval:</b> NA
<b>Date:</b> 10-11-18	<b>Date:</b> 10/11/18	<b>Date:</b> -

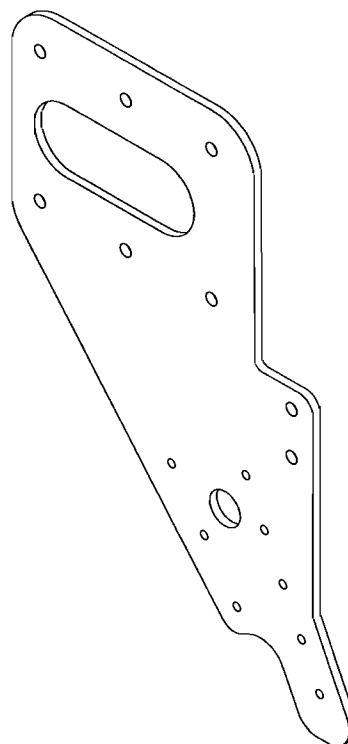
*inspected to PA1 Day only*

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





**D4274-1 PLATE, FWD SUPPORT**

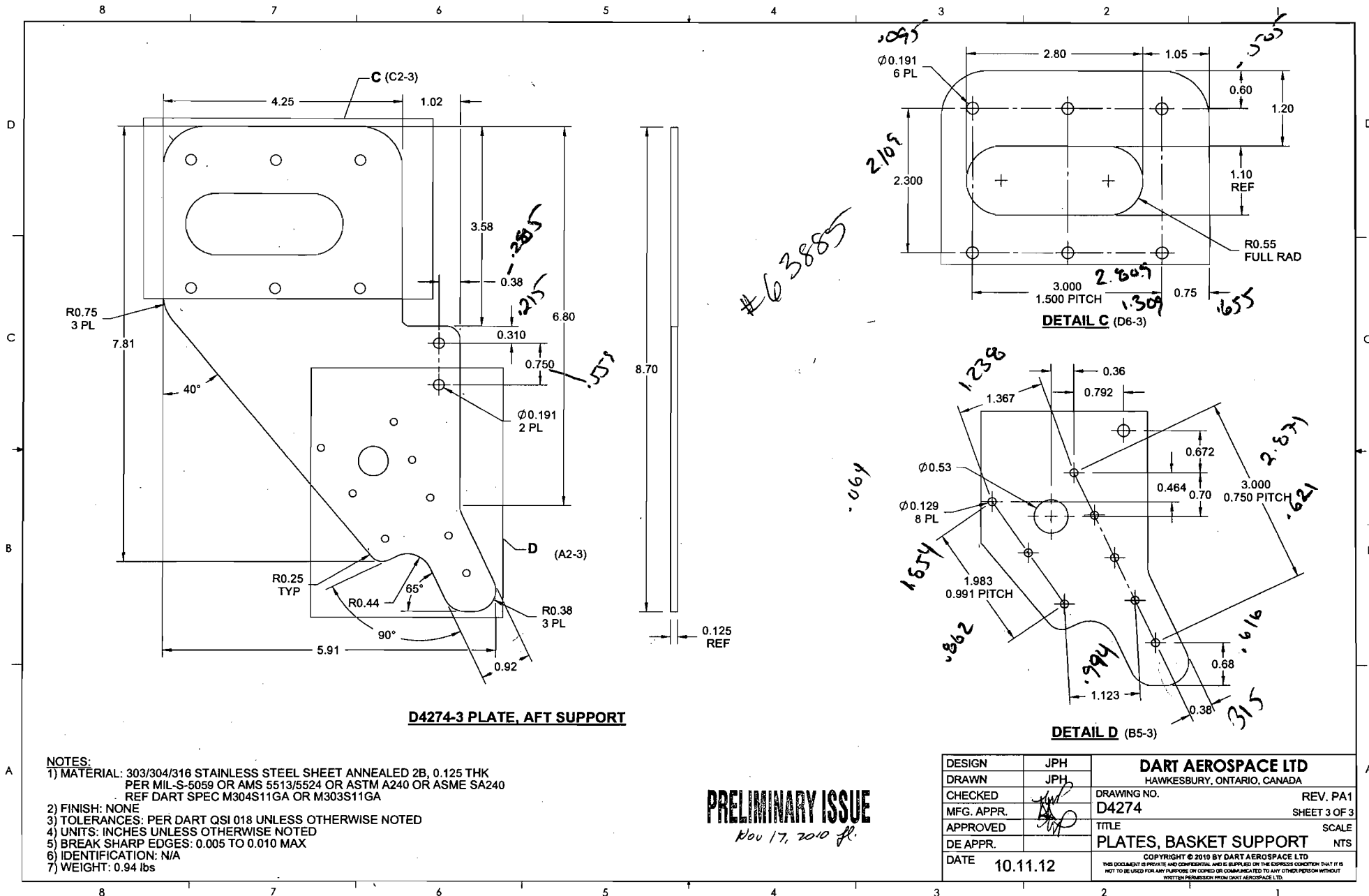


**D4274-3 PLATE, AFT SUPPORT**

#63885

**PRELIMINARY ISSUE**  
Nov 17, 2010

PA1	PRELIMINARY	JPH	10.11.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. PA1
MFG. APPR.	JPH	D4274	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



# Receiving Report

Date: 10/03/31

Batch No: M114799

Supplier: MAGNA

Dart P/O: 11923

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order S-10231 N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 10/03/31  
 Date [Signature]  
 Received/Costing [Signature]  
 Initial [Signature]

Location

## Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO11973	1		M304S16GA	sf	5/31/2010	5/31/2010	128.0000	\$5.03	0.0000	0	\$643.20
CAD	No		304/316 Sheet .063	sf	128.0000	DCUSER		\$643.20	0.0000	0	
			114799								
	2		M304S11GA	sf	5/31/2010	5/31/2010	128.0000	\$10.47	0.0000	0	\$1,340.16
	No		304/316 0.125 Sheet	sf	128.0000	DCUSER		\$1,340.16	0.0000	0	
			114799								
	3		M6061T6S.050	sf	5/31/2010	5/31/2010	128.0000	\$2.88	0.0000	0	\$368.00
	No		6061-T6 .050 Sheet	sf	128.0000	DCUSER		\$368.00	0.0000	0	
			114799								
Total Received Quantity:											384.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$2,351.36
Total Balance Due Quantity:											0.0000

**Magna Stainless**

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

**PACKING LIST**

Page 1 of 1

I027686

SHIPPED TO  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

## SPECIAL INSTRUCTIONS

\*\*\*\*\*STOCK\*\*\*\*\*

Contact: CHANTAL LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	11973	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W030353	NET 30 DAYS		NIR:R-557065-1	05/27/10	05/31/10	05/31/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	ALUMINUM SHEET ASH 6061 T6 .050" x 48" x 96" 92 LB / 4 PC MATERIAL IS PER QQA 250/11 AND PER AMS 4027	L037272	1615261	4
4		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" 336 LB / 4 PC MATERIAL AS PER ASTM A240	L038199	99020048	4
4		PC	SSH 304 2B 11ga x 48" x 96" 672 LB / 4 PC MATERIAL AS PER ASTM A240	I037542	7281937	4
Skids: 1				Approx Weight:		1,100 LB

Received by: \_\_\_\_\_ Date: \_\_\_\_\_ Signature: \_\_\_\_\_



## INSPECTION CERTIFICATE

CERTIFICATE NO.: YS-990165

CUSTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

INVOICE NO.: SSCAE40101TE9

CREDIT NUMBER: I700584

DESCRIPTION: STAINLESS STEEL SHEETS

DATE: 12 MAR, 2010

P008553  
8/10/05/13/ 25.4 + 1.5mm = 26.9mm

P/L NO.	SIZE	PCS	N.W. (KG)	SPEC	HEAT NO.	REFERENCE NO.
1	0.9MM X 1219MM X 2438MM	58	1214	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01A
2	0.9MM X 1219MM X 2438MM	58	1217	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-01AB
3	0.9MM X 1219MM X 3048MM	46	1204	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02A
4	0.9MM X 1219MM X 3048MM	46	1205	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-02AB
5	0.9MM X 1219MM X 3657MM	46	1445	304-2B/PAPER	9901419TM -990 20040	YERYCA9901A-03A
6	1.5MM X 1219MM X 2438MM	50	1757	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-04A
7	1.5MM X 1219MM X 2438MM	50	1760	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-05A
8	1.5MM X 1219MM X 2438MM	50	1756	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06A
9	1.5MM X 1219MM X 2438MM	35	1231	304-2B/PAPER	9901430YU -990 20048	YERYCA9901A-06AB
10	2.5MM X 1219MM X 3048MM	16	1168	304-2B/PAPER	9902069YU -990 20188	YERYCA9901A-07A

### Chemical Composition

### Mechanical Test

P/L NO.	C	Si	Mn	P	S	Ni	Cr	N	Cu	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	Hardness HV
1	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
2	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
3	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
4	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
5	0.041	0.300	1.300	0.029	0.001	8.000	18.09	-	-	-	281	625	56.0	157.0
6	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
7	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
8	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
9	0.044	0.530	1.190	0.036	0.001	8.020	18.27	0.0250	0.1900	0.0900	299	665	53.0	164.0
10	0.052	0.540	1.160	0.039	0.005	8.020	18.20	0.0270	0.2400	0.0900	309	648	53.0	177.0

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

YIEH CORPORATION LIMITED

Q.C. MANAGER

*Lin*



**AK Steel Corporation**  
**Metallurgical Test Report**  
**Rockport Works**  
**Rockport, IN 47635**

Page 1

Load No. 9220693  
 SRN No. 9220693

CUSTOMER

SHIP TO

MILL ORDER NO. 241851-2349 PROCESSOR ORDER NO. S17824 BUYERS ORDER NO. S17824

PART NO.

ENGLISH UNITS -PRODUCT- METRIC UNITS  
 .1200 NOM 48.0000 X COIL

S 1065131

COIL ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT	OUTSIDE PROCESSOR ID
212487-04RA	1	7281937	0212487-04B	13,160 LBS. 5,969 KG.	478338401
212487-04BB	1	7281937	0212487-04B	13,160 LBS. 5,978 KG.	478338402
212487-04BC	1	7281937	0212487-04B	13,158 LBS. 5,965 KG.	478338403
TOTAL COILS	TOTAL PIECES			TOTAL NET WEIGHT	
3	3			39,478 LBS. 17,912 KG.	

P041548  
 P041549  
 P041550

L=Ladle Analysis of Heat P=Product Analysis of Parent Coil

**CHEMICAL ANALYSIS**

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7281937	.022	1.491	.029	.0011	.369	18.23	8.24	.23	.0330	.38						

SHIPPING DATE: 02/06/2009

REMARKS: NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS WERE MADE OR USED THROUGHOUT THE PROCESSING AND TESTING OF THIS MATERIAL MATERIAL FREE OF RADIOACTIVE ISOTOPES MELTED AND MANUFACTURED IN THE USA

**PRODUCT DESCRIPTION**

CR SRT TYPE 304/304L STAINLESS #28 FINISH SLIT EDGE \* (ASTM A 240 -08) ASTM A 480 -08 EX PARA 25.1.1.3 COIL WILL BE TAGGED ON O OUTSIDE ONLY \* ASME SA-240 SECTION II PART A (2004 ED. 2005 ADDENDUM) \* ASME SA-480 SECTION II PART A (2004 ED. 2005 ADDENDUM) \* AS TM A 262 -02ANZ PRACTICE E \* EN 10204: 2004 (E) TYPE 3.1 \* ASTM A 866 -03 EX 7.1 TEST SPECIMENS WILL BE SELECTED IN THE TRANSVE RSE TEST DIRECTION IN ALL CASES \* AMS 5511 H

PARENT COIL	POS	DIR	COND	%ELONG	TENSILE STRENGTH (KSI)	Y.S. 1% OFFSET (KSI)	ROCKWELL HARDNESS Tem	ROCKWELL HARDNESS Front			
0212487-04B	T	T	A.S.T.M	52.7	92.2	49.9	B 68	B 87			

\*\*\* CONTINUED ON NEXT PAGE \*\*\*



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO11973**

Purchase Order Date 5/27/10

PO Print Date 5/27/10

Page Number 1 of 2

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
(2052)

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304S16GA	304/316 Sheet .063	5/31/10 Yes	128.00 sf	Yours ppd	\$5.0250	\$643.20
		Special Inst: MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240					
2	M304S11GA	304/316 0.125 Sheet	5/31/10 Yes	128.00 sf	Yours ppd	\$10.4700	\$1,340.16
		Special Inst: AS ABOVE					
3	M6061T6S.050	6061-T6 .050 Sheet	5/31/10 Yes	128.00 sf	Yours ppd	\$2.8750	\$368.00
		Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET AS PER QQ-A-250/11 OR AMS-QQ-A- 250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209					

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: I

Change Date: 5/27/10



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO11973**

Purchase Order Date 5/27/10

PO Print Date 5/27/10

Page Number 2 of 2

Order From :

VC-MAG002

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal-Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

PO Total:

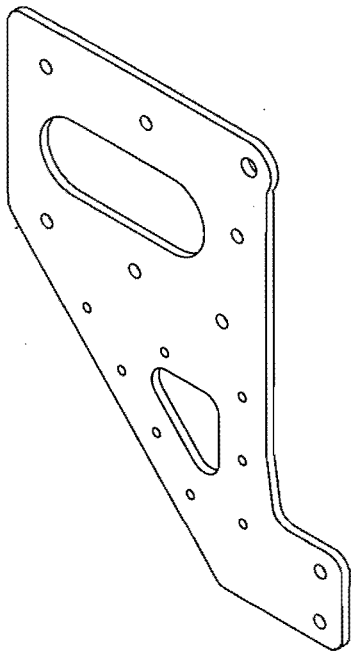
\$2,351.36

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

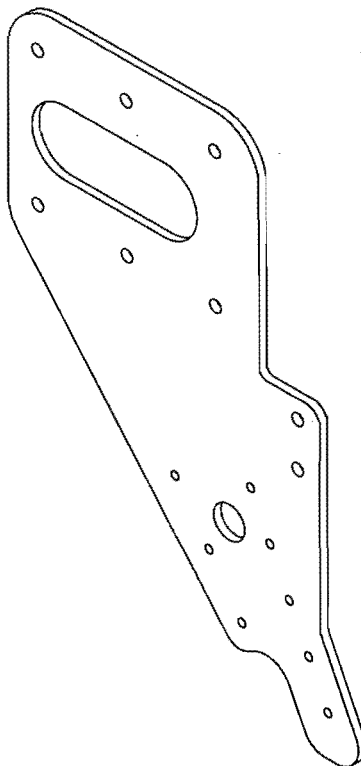
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 5/27/10

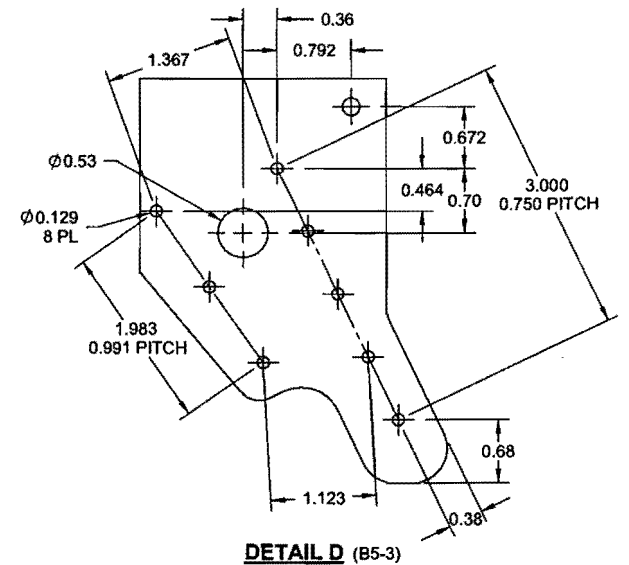
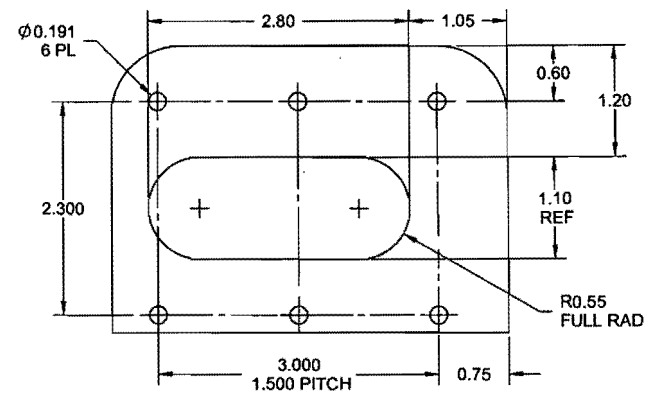
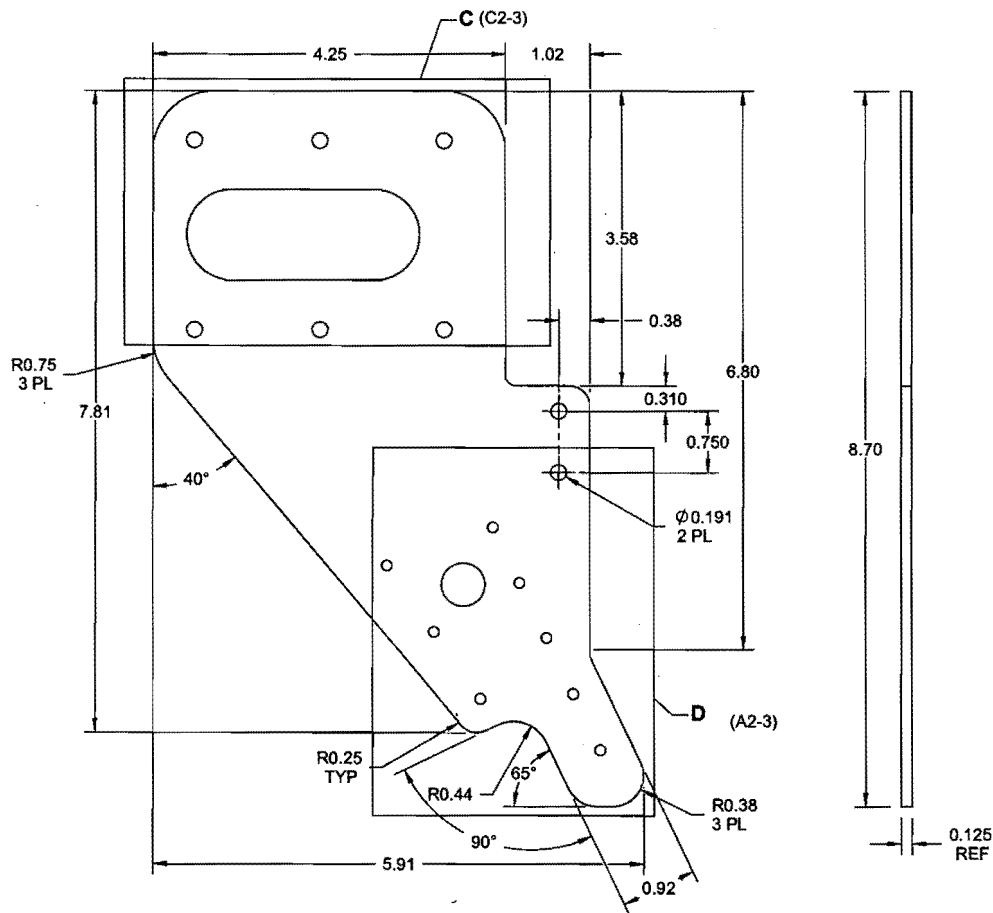


**D4274-1 PLATE, FWD SUPPORT**







**D4274-3 PLATE, AFT SUPPORT**

A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4274	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLATES, BASKET SUPPORT	NTS
DATE	10.11.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.94 lbs

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4274	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			